

Date: Wednesday, 8/30/2006 11:57:17 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BALL
 Job Number : 28359
 Estimate Number : 12508
 P.O. Number : N/A Part Number : D35211
 This Issue : 8/30/2006 S.O. No. : N/A Drawing Number : D3521 UNDER REVIEW CB 06.08.30
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : UNDER REVIEW
 Previous Run : N/A Material : N/A
 Written By : Due Date : 9/6/2006 Qty: 50 # Um: Each
 Checked & Approved By : 06.08.30
 Comment : EST A 06.08.21 NEW ISSUE EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 1940

Purchase Part Number: 9617K47

Supplier: MCMASTER

Certificate of conformity is required

06/08/30
 50

2.0

9617K47

BALL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 BALL

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- Drill & Tap hole as per dwg D3521 using indexing fixture.

2- Deburr & polish, ensure no flat spot created from clamping.

06/09/12 49 PTO

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/09/14 49

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

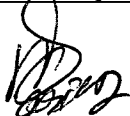

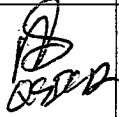
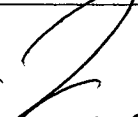

J.F. 06/09/14 49

Received + inspect for transit Damage
 ensure material cert is attached

06/09/14 50

PTO

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-09-05	2.4	Add A receiving as shown. Perm. change	E	06-09-28			 06-09-05	
06-09-05	26	Add A QC 5 for receiving. Perm. change	E	06-09-28			 06-09-05	
		QC 5		06-09-05	(50)			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *[Signature]* Date: 06/09/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/09/14	3.0	while TAPPING 10-32 Thread, Tap broke off INSIDE Brass Ball.	<i>[Signature]</i> <i>[Signature]</i>	Scrap & destroy. No replace no more left.	<i>[Signature]</i> 06/09/14	<i>[Signature]</i> 06-09-14	<i>[Signature]</i>	<i>[Signature]</i> 06-09-14
			<i>[Signature]</i>				<i>[Signature]</i>	

NOTE: Date & initial all entries

Date: Wednesday, 8/30/2006 11:57:17 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BALL

Job Number: 28359

Part Number: D35211

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51447

06/09/18

(49)

7.0

DC

DOCUMENT CONTROL



(49)

Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/18

Job Completion



06/09/18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

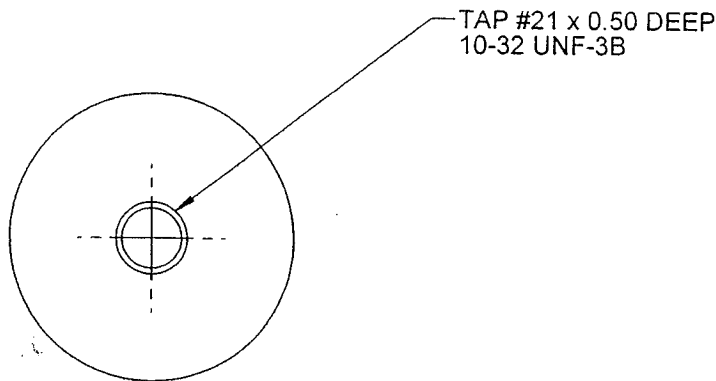
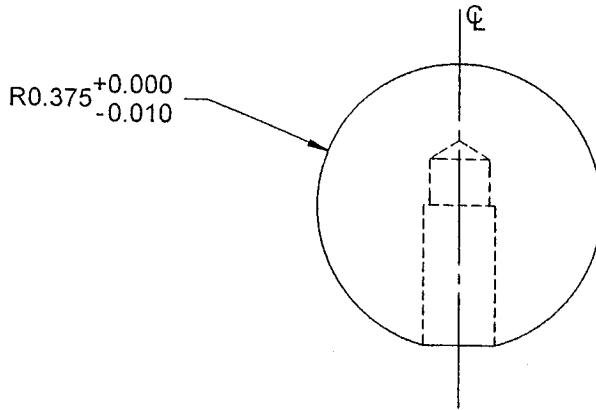
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3521	REV. A SHEET 1 OF 1
DATE 06.05.02		TITLE BALL	SCALE 2:1
A	06.05.02	NEW ISSUE	

~~UNDER REVIEW~~
~~06.08.22 CB~~ CB
~~prototype~~



D3521-1 BALL

NOTES:

- 1) MATERIAL: BRASS, Ø0.75 BALL (McMASTER P/N 9617K47)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT Φ

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **28359**

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6 DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY
MAIN FINISHED GOODS LOCATION

ON K6A 1

YOUR PURCHASE
ORDER NUMBER
P000001940

Today's Date: 8/30/06

MCMASTER-CARR
200 AURORA INDUSTRIAL PKWY
AURORA OH 44202

IF THERE ARE ANY QUESTIONS ABOUT THIS
SHIPMENT, CONTACT OUR SALES DEPARTMENT
(330)995-5500

PAGE
1 OF 1
MCM NUMBER
3379159-01

Warehouse Location	McMaster Carr Part Number	Fill Quantity	Item Description	Your Line	Your Order	This Shipment
1- 21-04	05-139617 K47	10 PK	ALLOY 260 BRASS BALL 3/4" DIAMETER PKG= 5 EA/PK 4	1	10 PK	10

DART AEROSPACE LTD	Work Order: 28359
Description: BALL	Part Number: D3521-1
Inspection Dwg: D3521 Rev: A	Page 1 of 1

Work Order:	28359
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Description: BALL

Part Number:	D3521-1
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Inspection Dwg: D3521 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article

x Prototype

[illegible]

Tolerance

**Actual
Dimension**

Accept

Reject

Method of Inspection

Comments

10x32x.50

±.030

500

RO.375

+ 010

RD.375

✓

Audited by:

56

Prototype Approval:

Date:

06/09/17

Date:

06709112

Date:

NIA

Rev

Date _____

Change

Revised by

Approved

A

New Issue

KJ/JLM